

Date: Monday, 6/5/2006 8:59:37 AM
 User: Linda Lacelle

Process Sheet

SP1.1
 2-06-13
 PTO

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SHORT STEP ASSEMBLY
 Job Number : 27396
 Estimate Number : 11999
 P.O. Number : NIA Part Number : D350591122
 This Issue : 6/5/2006 S.O. No. : NIA Drawing Number : D2351 REV E
 Prsht Rev. : NC Project Number : N/A
 First Issue : NIA Type : LARGE FAB ASSY Drawing Revision : E
 Previous Run : 25537 Material : NIA
 Written By : SEE COMMENT BELOW Due Date : 6/27/2006 Qty: 6 Um: Each
 Checked & Approved By :
 Comment : Est Rev:E 02.10.21 Re-format; Incorporated D2351-041 IPP K
 J/RF

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and type labels as per PPP D350-591-122 CHG003

KE 06.07.05

2.0 D2244116 Step Extrusion



Comment: Qty.: 0.5000 Each(s)/Unit Total: 3.0000 Each(s)

Pick:

Qty Part Number Description Batch
 0.5 D2244-128 Extrusion B23404

KE 06.06.05

3.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2244-128 extrusion to 55.32" long as per Dwg D2351 using cutting table setup DT8185-G

KE 06.06.05

2-Drill extrusion per Dwg D2351 using Jig DT8230 for rivets.

KE 06.06.05

3-Deburr

KE 06.06.05

4.0 BENDING BENDING MACHINE



Comment: BENDING MACHINE

Bend per Dwg D2351 using Bend Program D2351.2D

DP06-6-6

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Job Number:



Seq. #: Machine Or Operation:

Description:

5.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

BF 06-06-09

6.0 D28502

End Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D2850-2 End Bracket B9907

LE 06-06-09 6

7.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Bevel Fwd and Aft end for welding

2-Weld Aft End Bracket per QSI 004 & Dwg D2351 using Welding Jig DT8033
A/R Aluminum Rod 19173

3-Do not Grind Flush

LE 06-06-09 6

LE 06-06-09 6

LE 06-06-09 6

8.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FF 06-06-29 3

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

LE 06-07-4 3

10.0 D2582

Hi-Skid Step Leg Ass'y


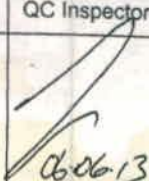


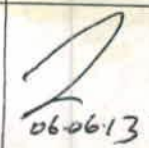




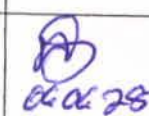
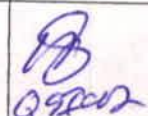

Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D2582 Step Leg Assy 325082-1 = 3

LE 06-07-4 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
060613	7.1	OK S/S Inspect work i weld.		060628	3		 060613
		Add to estimate permanent change 					
060613	7.1	Split w/o for 3 parts. 3 don't fit well and waiting for response.		060613	3		 060613

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
	7.1	fit is tight in sig after welding.	 060628	test initial the steps on the A/C. Fit is excellent.	 060628	 060628	 060628	 060628

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA:  Date: 06/07/24.

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

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Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

MS20600AD4W3

Cherry Rivets



Comment: Qty.: 16.0000 Each(s)/Unit Total : 96.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

16 MS20600AD4W3 Rivet

m13767 = 42
m101415 = 6

RE-06-07-04 3

12.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Rivet Leg Assembly as per Dwg D2351

RE-06-07-04 3

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

RE 06-07-04 3

14.0

D267334

End Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2673-34 End Plate *325396*

RE-06-07-04 3

15.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld Fwd End Plate per QSI 004 & Dwg D2351 *& grid flush*

A/R

Aluminum Rod

m100660

RE-06-07-04 3

16.0

QC5 *19*

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

PD 06-07-04 (3)
06-07-04 (3)

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch up Alodine

a.m 06-07-04 (3)

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Job Number:



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18.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

a.m 06-07-17

(3)

19.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk per Dwg D2351 and QSI 005 4.4

Batch: *M 101266*

SC 06/07/18 (7)
BL

20.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

21.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

22.0 D22301 Mounting Lug



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick:

Packing KitQty Part Number Description Batch

1 D2230-1 Mounting Lug *B237243*

23.0 D22303 Mounting Lug



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick:

Packing KitQty Part Number Description Batch

1 D2230-3 Mounting Lug *B26592*

24.0 D2856400 Abrasion Strip



Comment: Qty.: 0.6000 f(s)/Unit Total: 3.6000 f(s)

Pick:

Packing KitQty Part Number Description Batch

1 D2856-400 7.20" Abrasion Strip *B25656*

60

Process Sheet

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Job Number:



Seq. #:	Machine Or Operation:	Description :
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25.0	AN337A	Bolt
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Packing KitQty Part Number Description Batch

2 AN3-37A Bolt M13719

26.0	AN413A	Bolt
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Comment: Qty.: 3.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick:

Packing KitQty Part Number Description Batch

3 AN4-13a Bolt M101149

27.0	AN960JD10	Washer
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Packing KitQty Part Number Description Batch

4 AN960JD10 Washer M100343

28.0	AN960JD416	Washer
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Comment: Qty.: 6.0000 Each(s)/Unit Total : 36.0000 Each(s)

Pick:

Packing KitQty Part Number Description Batch

6 AN960JD416 Washer M100575

29.0	MS21042L3	Nut
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Packing KitQty Part Number Description Batch

2 MS21042L3 Nut (or -3) M100323

30.0	MS21042L4	Nut
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Comment: Qty.: 3.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick:

Packing KitQty Part Number Description Batch

3 MS21042L4 Nut (or -4) M19085

Rec'd 6/6/23 (2)

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Job Number:



Seq. #:

Machine Or Operation:

Description :

31.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

CS 07/05/06

(3)

32.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-591-122

Location: *✓*

PPP Rev: *C*

AS 06/07/06

(3)

33.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

06/07/06

(3)

Job Completion



U 06.07.06